

Work Order ID 141092

Tuesday, January 26, 2016 3:21:08 PM

141092

Page 1

Item ID: D2933-2BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 1/26/2016 Start Qty: 4.00 ***4*** 10 SAA Cust Item ID:
 Required Date: 1/26/2016 Req'd Qty: 4.00 ***4*** 10 Customer:
 Reference:

Approvals: Process Plan: MLJ Date: FEB 01 2016 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2933	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00
100 HAAS 1 Memo 0.08 10 0 16/03/02
 HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110 CONVENTIONAL MILLING MACHINE 0.00
110 Mill Conv Memo 0.00 10 0 16/03/02
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

120 QC1- Inspection performed by CMM 0.00
120 QC Memo 0.00 10 0 16/03/02
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Work Order ID 141092

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Item ID: D2933-2BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 1/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/26/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130						10	0		16/03/03
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	Spray Painting per QSI005 4.2	0.00							DAS 41 9-89
150						10			16-3-7
SprayPaint	Memo	0.00							
Spray Painting	***MASK ALL HOLES AS PER PAR16-484***								
	SPRAY PAINT BLUE	Prime	134188						
	BATCH: _____	Paint	134720						
		clear	129058						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 141092***141092***

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Tuesday, January 26, 2016 3:21:08 PM

Item ID: D2933-2BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH In, 206
Start Date: 1/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/26/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAR 08 2016
170	Identify as per dwg & Stock Location: <u>S4389</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									MAR 08 2016
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									MAR 08 2016

MCS MAR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

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Page 1

Work Order ID: 141092

141092

Parent Item: D2933-2BL

***D2933-2BL ***

Parent Item Name: Saddle RH In, 206

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM
15.10.09 ADDED BL DD VERF:JLM
PAR16-484 DD VERF:JLM

IPP REV:D
IPP REV:E 16.01.22

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	62.0000	1	4			

D6101-001

Saddle Billet

*610
16/22/29*

Location

Loc Qty

Loc Code

MAT042

62

132708

14

135956

34

137755

14

10

DQA: _____ Date: _____

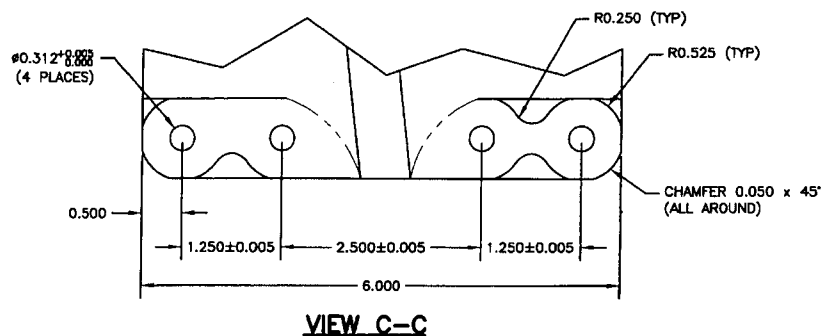


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

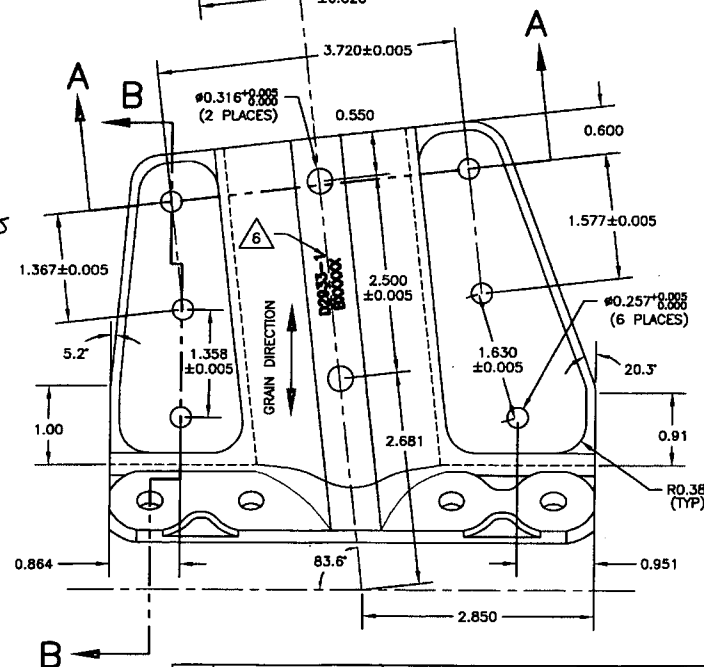
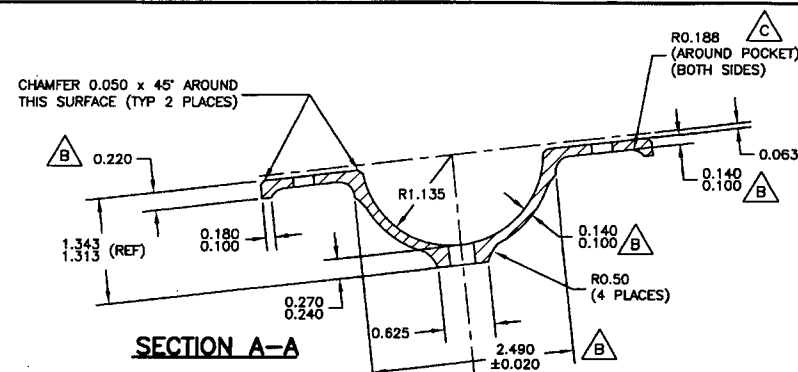
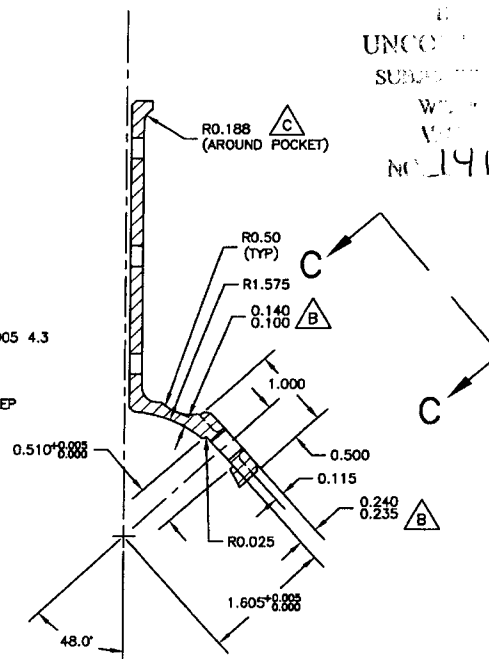
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	
CHECKED	APPROVED	
DATE	06.11.09	
DART	DART AEROSPACE USA, INC.	
D2933		
SADDLE INSIDE		

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REV. C
SHEET 1 OF 1
SCALE
2:3

DART AEROSPACE LTD	Work Order:	141092
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	.123	.121	.124		
B	0.100	0.140		0.126	.122	.123	.124		
C	0.100	0.140		0.115	.120	.116	.116		
D	0.210	0.230		0.225	.225	.223	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.235	0.235	0.236	0.236		
N	0.100	0.140		0.122	0.122	.122	.123		
O	0.540	0.560		0.548	0.547	.548	.548		
P	0.490	0.510		0.498	0.499	.498	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.252	0.252	.252	.251		
T	0.100	0.180		0.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.125	1.145		1.137	1.137	1.137	1.137		
Y	1.565	1.585	DT8695 A/B	1.578	1.578	1.578	1.578		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	<i>[Signature]</i>
Date:	16/03/03

Audited by:	<i>[Signature]</i>
Date:	16/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 141092
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	4 5	4 6	4 7	4 8		
A	0.100	0.140		0.126	0.126	0.126	0.127		
B	0.100	0.140		0.126	0.126	0.126	0.126		
C	0.100	0.140		0.120	0.121	0.121	0.121		
D	0.210	0.230		0.222	0.223	0.223	0.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.236	0.235	0.236	0.236		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.548	0.547	0.548	0.548		
P	0.490	0.510		0.500	0.498	0.499	0.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.252	0.252	0.251	0.253		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.125	1.145		1.136	1.136	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.578	1.578	1.578	1.578		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	<i>[Signature]</i>
Date:	16/03/03

Audited by:	<i>[Signature]</i>
Date:	16/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 141092
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	# 9	# 10	#	#		
A	0.100	0.140		0.125	0.125				
B	0.100	0.140		0.126	0.126				
C	0.100	0.140		0.118	0.118				
D	0.210	0.230		0.223	0.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.512	0.512				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.258	0.258				
L	0.312	0.317		0.314	0.314				
M	0.235	0.240		0.235	0.236				
N	0.100	0.140		0.121	0.121				
O	0.540	0.560		0.497	0.498				
P	0.490	0.510		0.499	0.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		0.252	0.252				
T	0.100	0.180		0.140	0.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.317	0.317				
X	1.125	1.145		1.137	1.137				
Y	1.565	1.585	DT8695 A/B	1.578	1.578				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓				

Measured by: <i>[Signature]</i>
Date: 16/03/03

Audited by: <i>[Signature]</i>
Date: 16/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



Part Number: D2933-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 141092

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
1	0.3120	+0.0050/0.0000	0.3121	0.3121	0.3122	0.3123	0.3120
2	0.5000	+0.0100/-0.0100	0.4989	0.4987	0.4980	0.4992	0.4991
3	1.2500	+0.0050/-0.0050	1.2496	1.2500	1.2496	1.2504	1.2501
4	2.5000	+0.0050/-0.0050	2.4999	2.5007	2.5010	2.4998	2.4999
5	1.2500	+0.0050/-0.0050	1.2499	1.2494	1.2482	1.2498	1.2497
6	6.0000	+0.0100/-0.0100	6.0011	6.0002	6.0003	6.0007	6.0004
7	0.2200	+0.0100/-0.0100	0.2258	0.2251	0.2252	0.2262	0.2256
8	1.1350	+0.0100/-0.0100	1.1332	1.1333	1.1335	1.1332	1.1334
9	0.0630	+0.0100/-0.0100	0.0590	0.0588	0.0599	0.0580	0.0600
10	0.1200	+0.0100/-0.0100	0.1233	0.1235	0.1230	0.1241	0.1225
11	1.3280	+0.0150/-0.0150	1.3286	1.3280	1.3279	1.3290	1.3283
12	3.7200	+0.0050/-0.0050	3.7192	3.7189	3.7187	3.7201	3.7181
13	0.3160	+0.0050/0.0000	0.3160	0.3161	0.3160	0.3160	0.3160
14	0.5500	+0.0100/-0.0100	0.5498	0.5484	0.5483	0.5490	0.5488
15	0.6000	+0.0100/-0.0100	0.5977	0.5968	0.5975	0.5977	0.5971
17	1.5770	+0.0050/-0.0050	1.5774	1.5776	1.5775	1.5770	1.5775
17	0.2570	+0.0050/0.0000	0.2572	0.2574	0.2577	0.2575	0.2577
18	20.3000	+0.5000/-0.5000	20.2467	20.2584	20.2529	20.2603	20.2534
19	1.6300	+0.0050/-0.0050	1.6301	1.6296	1.6299	1.6296	1.6307
20	0.9510	+0.0100/-0.0100	0.9531	0.9540	0.9540	0.9543	0.9538
21	2.8500	+0.0100/-0.0100	2.8511	2.8501	2.8504	2.8502	2.8503
22	83.6000	+0.5000/-0.5000	83.5602	83.5600	83.5605	83.5610	83.5582
23	2.6810	+0.0100/-0.0100	2.6801	2.6857	2.6847	2.6856	2.6850
24	2.5000	+0.0050/-0.0050	2.5003	2.4999	2.5006	2.4998	2.4998
25	0.8640	+0.0100/-0.0100	0.8626	0.8618	0.8626	0.8623	0.8621
26	1.3580	+0.0050/-0.0050	1.3589	1.3584	1.3581	1.3590	1.3592
27	5.2000	+0.5000/-0.5000	5.1242	5.1418	5.1405	5.1196	5.1319
28	1.3670	+0.0050/-0.0050	1.3682	1.3674	1.3683	1.3676	1.3673
Ang29	48.000	+0.500/-0.500	47.970	47.872	47.885	47.873	47.874
30	1.6050	+0.0050/0.0000	1.6084	1.6050	1.6050	1.6100	1.6100
D31	0.235	+0.005/0.000	0.238	0.238	0.238	0.239	0.239
32	0.5000	+0.0100/-0.0100	0.4982	0.4998	0.4984	0.4994	0.4983

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2933-2	Rev: C	- Page 2 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 141092

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
33	1.5750	+0.0100/-0.0100	1.5722	1.5776	1.5770	1.5781	1.5771
34	0.0630	+0.0100/-0.0100	0.0605	0.0640	0.0636	0.0638	0.0652
D35	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	0.040
D36	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
D37	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
D38	0.120	+0.020/-0.020	0.123	0.123	0.123	0.124	0.124
D39	2.490	+0.020/-0.020	2.490	2.490	2.490	2.490	2.490
D40	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D41	0.255	+0.015/-0.015	0.253	0.251	0.252	0.253	0.252
D42	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D43	0.115	+0.010/-0.010	0.115	0.114	0.115	0.114	0.115
D44	1.000	+0.010/-0.010	1.003	1.004	1.004	1.004	1.005
D45	0.120	+0.020/-0.020	0.119	0.120	0.117	0.117	0.120
D46	0.510	+0.005/0.000	0.513	0.514	0.513	0.513	0.512

Measured by:
Mathieu Lamarche

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2016-3-3

Audited by:

Date:



Part Number: D2933-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 141092

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
1	0.3120	+0.0050/0.0000	0.3120	0.3127	0.3130	0.3124	0.3124
2	0.5000	+0.0100/-0.0100	0.4976	0.4981	0.4980	0.4978	0.4998
3	1.2500	+0.0050/-0.0050	1.2490	1.2505	1.2505	1.2505	1.2494
4	2.5000	+0.0050/-0.0050	2.5004	2.5002	2.4996	2.5001	2.5001
5	1.2500	+0.0050/-0.0050	1.2501	1.2494	1.2499	1.2492	1.2493
6	6.0000	+0.0100/-0.0100	6.0005	6.0008	6.0005	5.9997	6.0009
7	0.2200	+0.0100/-0.0100	0.2252	0.2261	0.2254	0.2253	0.2251
8	1.1350	+0.0100/-0.0100	1.1333	1.1333	1.1332	1.1333	1.1333
9	0.0630	+0.0100/-0.0100	0.0591	0.0588	0.0597	0.0596	0.0594
10	0.1200	+0.0100/-0.0100	0.1230	0.1242	0.1238	0.1233	0.1236
11	1.3280	+0.0150/-0.0150	1.3282	1.3289	1.3284	1.3283	1.3282
12	3.7200	+0.0050/-0.0050	3.7196	3.7191	3.7192	3.7191	3.7189
13	0.3160	+0.0050/0.0000	0.3160	0.3161	0.3160	0.3160	0.3160
14	0.5500	+0.0100/-0.0100	0.5489	0.5489	0.5487	0.5476	0.5492
15	0.6000	+0.0100/-0.0100	0.5961	0.5972	0.5978	0.5984	0.5969
17	1.5770	+0.0050/-0.0050	1.5787	1.5776	1.5778	1.5755	1.5775
17	0.2570	+0.0050/0.0000	0.2575	0.2574	0.2574	0.2573	0.2578
18	20.3000	+0.5000/-0.5000	20.2469	20.2682	20.2629	20.2629	20.2720
19	1.6300	+0.0050/-0.0050	1.6299	1.6296	1.6299	1.6298	1.6301
20	0.9510	+0.0100/-0.0100	0.9539	0.9539	0.9532	0.9540	0.9550
21	2.8500	+0.0100/-0.0100	2.8510	2.8505	2.8501	2.8499	2.8501
22	83.6000	+0.5000/-0.5000	83.5691	83.5623	83.5612	83.5554	83.5565
23	2.6810	+0.0100/-0.0100	2.6851	2.6847	2.6850	2.6844	2.6850
24	2.5000	+0.0050/-0.0050	2.4998	2.5000	2.5002	2.5008	2.5003
25	0.8640	+0.0100/-0.0100	0.8630	0.8629	0.8620	0.8620	0.8621
26	1.3580	+0.0050/-0.0050	1.3585	1.3592	1.3582	1.3586	1.3591
27	5.2000	+0.5000/-0.5000	5.1458	5.1491	5.1402	5.1512	5.1334
28	1.3670	+0.0050/-0.0050	1.3681	1.3677	1.3678	1.3680	1.3677
Ang29	48.000	+0.500/-0.500	47.886	47.890	47.882	47.876	47.872
30	1.6050	+0.0050/0.0000	1.6100	1.6100	1.6100	1.6100	1.6100
D31	0.235	+0.005/0.000	0.239	0.238	0.239	0.238	0.238
32	0.5000	+0.0100/-0.0100	0.4987	0.4998	0.4985	0.4996	0.4991

Measured by:
Mathieu Lamarche

Date:
2016-3-3

Audited by:

Date:



Part Number: D2933-2	Rev: C	- Page 2 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 141092

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
33	1.5750	+0.0100/-0.0100	1.5771	1.5766	1.5775	1.5767	1.5777
34	0.0630	+0.0100/-0.0100	0.0639	0.0633	0.0651	0.0638	0.0645
D35	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	0.040
D36	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
D37	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
D38	0.120	+0.020/-0.020	0.123	0.123	0.124	0.123	0.123
D39	2.490	+0.020/-0.020	2.490	2.490	2.490	2.490	2.490
D40	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D41	0.255	+0.015/-0.015	0.252	0.253	0.253	0.252	0.253
D42	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D43	0.115	+0.010/-0.010	0.114	0.115	0.115	0.114	0.114
D44	1.000	+0.010/-0.010	1.004	1.004	1.005	1.004	1.004
D45	0.120	+0.020/-0.020	0.117	0.120	0.120	0.117	0.117
D46	0.510	+0.005/0.000	0.512	0.513	0.513	0.513	0.513

Measured by:
Mathieu Lamarche

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